

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008810**Date Inspected:** 23-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 715**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|---------|---------------------|-----------------|----------------------------------|-----|----|-----|
| CWI Name: | N/A | CWI Present: | Yes | No | | | |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No | N/A |
| | | | | Delayed / Cancelled: | Yes | No | N/A |
| Bridge No: | 34-0006 | Component: | OBG Fabrication | | | | |

Summary of Items Observed:

CWI Inspectors: NA

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Bay 2

ZPMC issued "Inspection Notification Sheet" number 4046 informing Caltrans QA that ZPMC has completed ultrasonic inspections of the following OBG floor beam welds: FB3001-001-021, FB3001-001-50, FB3001-001-26, FB3086-001-23, FB3086-001-31, FB3086-001-26, FB3053-001-21, FB3053-001-50, FB3053-001-26, FB3038-001-023, FB3038-001-031, FB3038-001-026, FB3051-001-023, FB3051-001-050, FB3051-001-026, FB3055-001-021, FB3055-001-050, FB3055-001-026, FB3085-001-023, FB3085-001-03 and FB3085-001-026. This QA Inspector visually observed that floor beam FB3001-001-021 has a weld crown reinforcement of approximately 4 mm and AWS D1.5 indicates that the maximum allowable reinforcement is 3 mm. This QA inspector informed ZPMC CWI Mr. Li Zhi Jiang who concurred that this weld is visually rejectable and that he will have the weld crown ground to remove the excessive weld reinforcement. This QA Inspector later observed that ZPMC has ground the weld crown of FB3001-001-021 for a length of approximately two meters and that the weld crown reinforcement is now less than 3mm in height. This QA Inspector performed ultrasonic inspections of approximately 10 percent length on each of the welds listed above and items observed by

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this QA Inspector appear to comply with AWS D1.5 UT requirements. For additional information on these inspections see the TL6027 Ultrasonic Test Report.

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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| Inspected By: | Dawson,Paul | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
